

Job Set #41



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3204-3

Job Sheet 174393



Part No: D3204-3

Job Qty: 4 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/14/18

Job Tracking No:

Due Date: 4/7/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/6/18	0.00	0.00	Start Up Machining-2	20ML	DJP 18-7-5
100	Bandsaw	4 pcs		4/6/18	0.00	0.01	Bandsaw1	20ML	DJP 18-7-5
110	CNC Vertical Machining	4 pcs		4/7/18	0.33	1.20	HAAS1-3	20ML	DJP 18-7-5
130	QC	4 pcs		4/7/18	0.00	0.00	QC8 Machining-2		20ML 18/07/18
140	Packaging	4 pcs		4/7/18	0.00	0.00	Packaging3-1		EL
150	QC21-SA	4 Ea		4/7/18	0.00	0.00	QC21		

Part Op 100 - Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

Descriptions: 110 - 1- Machine as per Folio FA344 and Dwg D3204 Identify as D3204-3

140 - LOCATION : WA002

DAS
21
9-88

JUL 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X02.000	6061-T6 Bar .500 X 2.00	2.2152 ft (.5538 ea)	90-Start up Operation	S008430

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X02.000	2	25	0



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CANADA
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Container No: S089486



Part: D3204-3

Job No: 174393

Serial No/Batch: S089486

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/06/18



Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	6.000Inches ± 0.030	6.030 5.970		
2	Arm	5.250Inches ± 0.030	5.280 5.220		
3	Arm	0.776Inches ± 0.010	0.786 0.766		
4	Arm	0.760Inches $+ 0.005$ $- 0.000$	0.765 0.760	Diameter	
5	Arm	0.080Inches ± 0.010	0.090 0.070		
6	Arm	0.500Inches ± 0.010	0.510 0.490	Radius	
7	Arm	2.373Inches ± 0.010	2.383 2.363		
8	Arm	0.750Inches ± 0.010	0.760 0.740		
9	Arm	0.380Inches ± 0.010	0.390 0.370	Radius	
10	Arm	0.375Inches $+ 0.001$ $- 0.000$	0.376 0.375	Diameter	
11	Arm	0.300Inches ± 0.010	0.310 0.290		

Plex 3/14/18 4:03 PM Dart.Gagnon.Michelle

